₩)ate: User: Friday, 30/05/2008 10:12:20 AM

Julie Lecocq

Process Sheet

Customer **Job Number** : CU-DAR001 Dart Helicopters Services

: 39587

Estimate Number P.O. Number

This Issue

Previous Run

: 30/05/2008 : NC

Prsht Rev. First Issue

: // : 37303

: 10503

Type

By:EC

: MACHINED PARTS

S.O. No. :

Part Number

Drawing Name

: D2745

Drawing Number

. D2745 REV B

: BUSHING

Project Number

: N/A : B

Drawing Revision Material

Due Date

: 10/06/2008

Qtv:

150 Um:

Each

Written By

Checked & Approved By

Comment

: Est C 02.03.07 Update to turn in house NG Est Rev:D 07-10-23

Removed tumbling

JLM Verified

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M303R0750

303 Round Bar .75"



Comment: Qtv.:

0.1007 f(s)/Unit

Total: 15.1043 f(s)

303 ROUND .75"

Machine per Folio FA201 Material: AISI 303 SS

Batch: MO > 857

mm= 08/06/3

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Dwg D2515

2-Deburr



3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8





Comment: SECOND CHECK



5.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Page 1

Form: rprocess

W/O:		WORK ORDER CH	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
	;										
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:					

NCR:		W	ORK ORI	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	Annewal
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector
		• .	,					
 								

NOTE: Date & initial all entries

QA: N/C Closed: ____ Date: ____

Date:

Friday, 30/05/2008 10:12:20 AM

User:

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 39587

Part Number: D2745

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



159

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-05

Dart Ae	rospace	Ltd							
W/O:			V	ORK ORDER CHANG	GES				
DATE	STEP	PRO	DCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			, * '						
			. ,						
Part No	:	PAR #:	Fault Ca	tegory:					
							i:	_ Date: _	
NCR:		\	NORK OR	DER NON-CONFORM	ANCE (NC	₹)			
		Description of NC		Corrective Action Sec	tion B	Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	ign & Section C		Chief Eng	QC Inspector
•		,					;		
i									

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	39581
Description: Bushing	Part Number:	D2745
Inspection Dwg: D2745 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.060	+/-0.010	.0574	$\sqrt{}$			
0.400	+/-0.010	,395	V			
0.060	+/-0.010	6002				
1.020	+/-0.010	1.0170				
0.030 x 20°	+/-0.010	°030×50€				
Ø0.472	+/-0.010	8.472	1			
Ø0.375	+0.006/-0.001	Ø.377	6			
Ø0.560	+/-0.010	8.561				
Ø0.750	+/-0.010	\$ 747				. 2-1
						: 1
						N
						4
·						

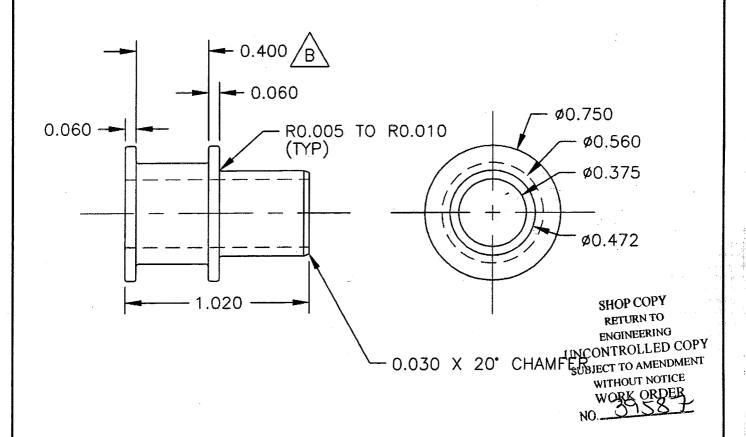
Measured by:	mm2/10	Audited by:	- Jul	Prototype Approval:	N/A
Date:	08/06/03	Date:	08/06/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.04.20	New Issue	KJ/RF	
В	07.11.26	Tolerance for Ø0.375 revised	KJ/EC/DD	<i>X</i>



DESIG	W.	DRAWN BY		AEROSPACE	
CHECK		APPROYED	DRAWING NO.		REV. B
P	#	KE	D2745		SHEET 1 OF 1
DATE		· · · · · · · · · · · · · · · · · · ·	TITLE		SCALE
98.1	0.23		BUSHING		2:1
Α		98.04.16	NEW ISSU	JE	
В		98.10.23	DIM 0.40	0 WAS 0.380	

RELEASED PS DS



MATERIAL: AISI 303 STAINLESS STEEL

NOTES: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RADIUS ALL INSIDE EDGES 0.005 TO 0.010

BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020

ALL DIMENSIONS ARE IN INCHES